

Date: Wednesday, 11/06/2008 11:02:57 AM
 User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	JACK SADDLE
Job Number :	39817		
Estimate Number :	11177		
P.O. Number :		Part Number :	D2281
This Issue :	11/06/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D2281 REV G
First Issue :	1/1	Project Number :	N/A
Previous Run :	37445	Drawing Revision :	G
	Type :	Material :	
	SMALL /MED FAB	Due Date :	27/06/2008
Written By :		Qty:	100
Checked & Approved By :	JUL 08.6.11	Um:	Each
Comment :	Est Rev:A Removed from 9 Digit 05-12-02 JLM Est: rev B 06.07.17 waterjet EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S14GA	304SS .080
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Comment: Qty.: 0.1313 sf(s)/Unit Total : 13.1250 sf(s)

304SS .080

batch: 107244 HB 8-6-12

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------

**Comment:** FLOW WATER JET

1-Cut as per Dwg D2281

Dwg Rev: G

Prog Rev: G

2-Deburr if necessary

HB 8-6-12

HB 8-6-12



3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------

**Comment:** SECOND CHECK

count
 508/6/13 (HB)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------

**Comment:** Deburr

at A Done at step 2.2

508/6/13

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: JACK SADDLE

Job Number: 39817

Part Number: D2281

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Form as per D2281 using D2281-T2

SB 08/06/17 (88)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/06/17 counter (88)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 22

8/6/17 SP

(V 88)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/06/19

Job Completion



22 08/06/18

Dart Aerospace Ltd

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DART AEROSPACE LTD		Work Order: 39817
Description: Jack Saddle		Part Number: D2281
Inspection Dwg: D2281 Rev: G		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.468	+/-0.010	4.470 *				
4.114	+/-0.010	4.114 *				
2.933	+/-0.010	2.938 *				
1.535	+/-0.010	1.534 *				
0.354	+/-0.010	.355 *				
0.354	+/-0.010	.354 *				
0.604	+/-0.010	.604 *				
2.000	+/-0.010	2.002 *				
3.396	+/-0.010	3.396 *				
3.646	+/-0.010	3.646 *				
4.000	+/-0.010	4.005 *				
1.525	+/-0.010	1.522 *				
2.475	+/-0.010	2.476 *				
Ø0.323	+0.006/-0.001	.325 *				
0.080	+/-0.010	.076 *				

Measured by: IB
Date: 8-6-13

Audited by: S
Date: 08/06/13

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.09.08	New Issue	KJ/JLM	[Signature]

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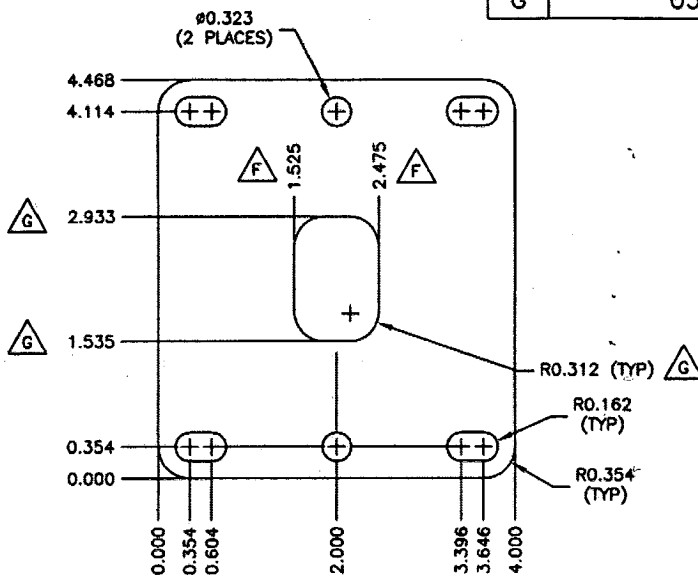
QA: N/C Closed: _____ Date: _____

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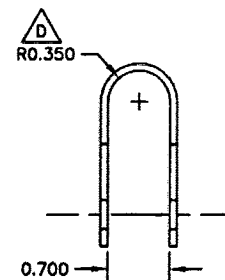
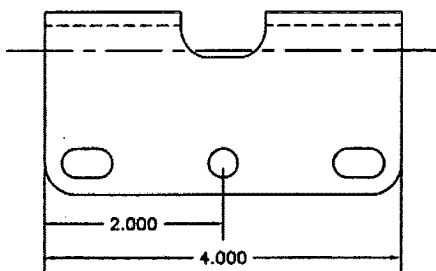
NOTE: Date & initial all entries :

DART

DESIGN BW	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2281	REV. G SHEET 1 OF 1
DATE 05.06.07	TITLE JACK SADDLE	SCALE 1:2	
A	94.10.14	NEW ISSUE	
B	94.10.18	DIMENSION WAS 2.878	
C	94.11.04	ADD TOOLING NOTCH	
D	98.03.27	R0.350 WAS R0.280	
E	04.11.18	REMOVE TOOLING NOTCHES	
F	05.03.16	REDESIGN FLAT PATTERN	
G	05.06.07	REDESIGN FLAT PATTERN	

RELEASED
[Signature]
05/08/11

FLAT LAYOUT

**D2281 JACK SADDLE**

- 1) MATERIAL: 304/316 SS, 0.080 THICK (REF DART SPEC. M304S14GA)
- 2) FINISH: NONE
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 39811

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Dart Aerospace Ltd

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